

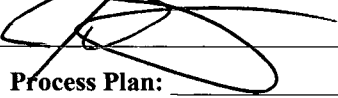
# Work Order ID 123193

\*123193\*

Page 1

July-31-14 11:51:40 AM

Item ID: D5127-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Shim, Large  
 Start Date: 31/07/2014 Start Qty: 12.00 \*12\* Cust Item ID:  
 Required Date: 06/08/2014 Req'd Qty: 12.00 \*12\* Customer:

Reference:   
 Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5127	REV A

100	BAND SAW	0.00							
*100*									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank:2.250" LONG								

DAS 02 14-08-02 x13  
9-89

110	HAAS CNC VERTICAL MACHINING #1	0.00							
*110*									
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	1- Machine as per Folio FB326 and Dwg								
	FOLIO REV: AA								
	DWG REV: A								
	- Deburr								

DAS 02 14-08-02 x13  
9-89

# Work Order ID 123193

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**\*123193\***

Page 2

Item ID: D5127-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Shim, Large  
Start Date: 31/07/2014 Start Qty: 12.00 **\*12\*** Cust Item ID:  
Required Date: 06/08/2014 Req'd Qty: 12.00 **\*12\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

DAS  
02 *14* 08 *02*  
9-89

*14/08/03*

*13* *13*

*13* *16148.5*

# Work Order ID 123193

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**\*123193\***

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Item ID: D5127-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Shim, Large

Start Date: 31/07/2014 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 06/08/2014 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

141

QC7-Inspect Chemical Conversion Coat

0.00

**\*141\***

QC

Memo

0.00

Quality Control

13

DAS

41

9-89

14-8-6

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*150\***

Powdercoat

Memo

0.00

Powder Coating

128959

13

DAS

41

9-89

14-8-6

START TIME:

340

OVEN TEMPERATURE:

320

FINISH TIME:

410

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

13

14/08/07

14/08/07

14/08/07

# Work Order ID 123193

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\*123193\*

Page 4

Item ID: D5127-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Shim, Large  
 Start Date: 31/07/2014 Start Qty: 12.00 \*12\* Cust Item ID:  
 Required Date: 06/08/2014 Req'd Qty: 12.00 \*12\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							DAS
*170*									32
Packaging	Memo	0.00							8-89
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
*180*									
QC	Memo	0.00							
Quality Control									

14/8/17 13

ML5 1408-07

ML5 1408-07

# Picklist Print

July-31-14 11:51:38 AM

Page 1

Work Order ID: 123193

\*123193\*

Parent Item: D5127-1

\*D5127-1\*

Parent Item Name: Shim, Large

Start Date: 31/07/2014

Required Date: 06/08/2014

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 14-07-30 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X02.00 0		Purchased	No				f	182.0000		2.6			

\*M6061T6B0 250X02 000\*

6061T6 Bar .250 X 2.00

\*\*

DAS

02

9-89

14-08-02

Location

Loc Qty

Loc Code

MAT049

182

122081

10

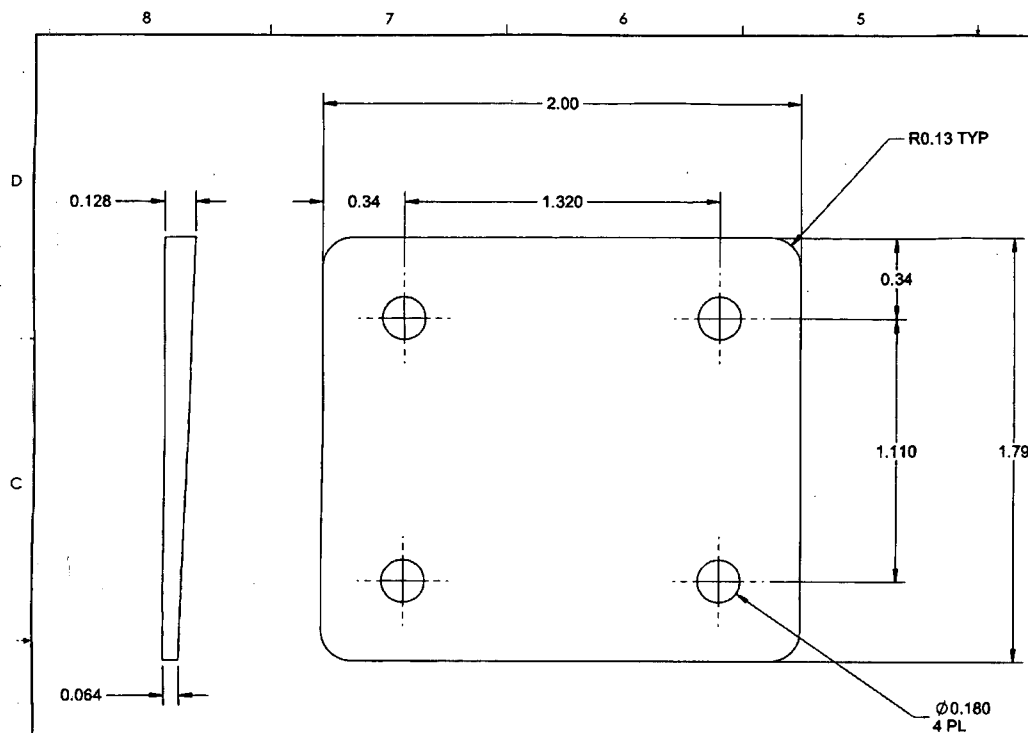
123137

100

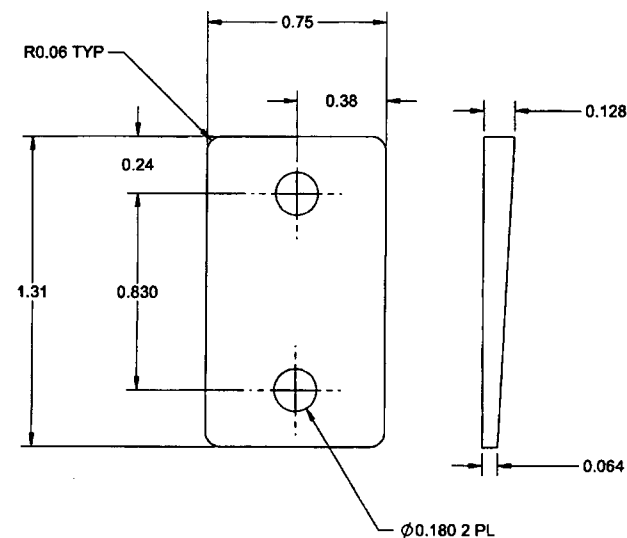
123279

72

2.6



**D5127-1 SHIM LARGE**



**D5127-3 SHIM SMALL**

**RELEASED**  
2014-07-28

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5127-1" OR "D5127-3" PER QSI 044 6.7
- 7) WEIGHT: D5127-1: 0.03 lbs, D5127-3: 0.01 lbs

APPROVED	A	NEW ISSUE	DB	14.07.09
	REV.	DESCRIPTION	BY	DATE
	DESIGN	DB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
	DRAWN	DB		
	CHECKED	ML	DRAWING NO.	REV. A
	MFG. APPR.	JLM	<b>D5127</b>	SHEET 1 OF 1
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	<b>SHIM</b>	NTS
	DATE	14.07.09	<small>COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMBINED WITH ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

## FIRST ARTICLE INSPECTION CHECKLIST

**DAS**

10.04.15